



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5127-1
Job Sheet 202144



Part No: D5127-1

Part Name: Shim, Large

Job Qty: 6 pcs

20 pcs. D.A.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/21/19

Job Tracking No:

Due Date: 11/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 14-07-30 JLM VERIFIED BY:DD

Ship Via:

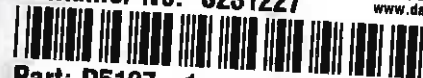
Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs	11/15/19	11/15/19	0.00	0.40	Bandsaw - 1		Marie L 19/11/19
110	HAAS 4 Axis - B4B	6 pcs	11/15/19	11/15/19	1.00	1.91	HAAS - 1 - B4B		Marie L 19/11/19
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	6 pcs	11/15/19	11/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		Marie L 19/11/19
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Container No: S231227



Part: D5127-1

Job No: 202144

Serial No/Batch: S231227

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/13/19

Dart Aerospace Ltd.
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CANADA
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130 QC 8	6 pcs	11/15/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	Done 11/11/18
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
140 Handfinish - 1-1 Chemical-B4B	6 pcs	11/15/19	0.00 0.19	QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				Handfinish - 1 - 1 - B4B	BEB 11-11-19
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 -	

				B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
141 QC 7	6 pcs	11/15/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	BK 19-11-22
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
150 Powdercoat - 1 White GI(A)- B4B	6 pcs	11/15/19	0.00 0.04	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BK 19-11-22
				Powdercoat - 4 - B4B	
160 QC 3	6 pcs	11/15/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	

					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
170	Packaging 3-1 - Stock - B4B	6 pcs	11/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180	QC 21 - SA	6 pcs	11/15/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

DAS
NOV 22 2019 40
9-89

DAS
21
9-89 NOV 25 2019

Part Op 100 - Cut blank:2.250" LONG
Descriptions: 110 - (HAAS CNC Vertical Machine), 1- Machine as per Folio FB326 and Dwg FOLIO REV: AA DWG
REV: A - Deburr

120 - QC2- Inspect parts off machine FAI/FAIB
130 - QC8- Inspect parts - second check
140 - Chemical Conversion Coat per QSI005 4.1
141 - QC7-Inspect Chemical Conversion Coat
150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 11:00 OVEN TEMPERATURE: 300°
FINISH TIME: 12:15 M 211886
160 - QC3- Inspect Part Finish
170 - Identify as per dwg & Stock Location:
180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.250X02.000	6061-T6 Bar .250 X 2.00	1.1250 ft (.1875 ea)	100-Bandsaw - 1	E123137-3.82

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.250X02.000	1	151	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Shim, Large	0.064Inches ± 0.010	0.074 0.054	OC5	
2	Shim, Large	0.128Inches ± 0.010	0.138 0.118	.128	
3	Shim, Large	0.340Inches ± 0.030	0.370 0.310	0.336	
4	Shim, Large	2.000Inches ± 0.010	2.010 1.990	1.995	
5	Shim, Large	1.320Inches ± 0.010	1.330 1.310	1.317	
6	Shim, Large	0.340Inches ± 0.030	0.370 0.310	0.336	
7	Shim, Large	1.110Inches ± 0.010	1.120 1.100	1.109	
8	Shim, Large	1.790Inches ± 0.030	1.820 1.760	1.786	
9	Shim, Large	0.180Inches + 0.005 - 0.001	0.185 0.179	Diameter 180	

Plex 10/21/19 8:20 AM Dart.lajeunesse.marie

